









Work Order ID 71998




Friday, July 15, 2011 10:36:12 AM



Page 1

Item ID: D3684-043 Accept  Setup Start 
Revision ID:
Item Name: MOUNT ASSEMBLY Stop 
Start Date: 7/15/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 7/22/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan:  Date: 7/15/11 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3684	Rev D								
100	Pick Kit	0.00							
									
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
									
Small Fab	Memo	0.00							
Small Fab	1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 □ 2-Assemble D3684-049 & D3687-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684□***Ensure holes for AN3C Bolts are free o								
120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

EP 11/07/11 (2)

EP 11/07/11 (2)

EP 11/07/11 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71998



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Item ID: D3684-043 Accept  Setup Start 
Revision ID:
Item Name: MOUNT ASSEMBLY Stop 
Start Date: 7/15/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 7/22/2011 Req'd Qty: 2.00  Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: <u>77</u> Memo	0.00 0.00					11/7/19	5/20	
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/7/20	MF 11-07-19

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 71998

Parent Item: D3684-043

Parent Item Name: MOUNT ASSEMBLY





Start Date: 7/15/2011

Required Date: 7/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A  Bolts		Purchased	No			110	Each	40.0000	4	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				40					
				117514				4					
				118112				36					
D3684-047  FWD LEG ASS'Y		Manufactured	No			110	Each	0.0000	1	2			
D3684-049  AFT LEG ASS'Y		Manufactured	No			110	Each	2.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST078				2					
				68370				2					
D3687-1  MOUNT		Manufactured	No			110	Each	2.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2					
				61971				2					

8/11/07/19

8/11/07/19

8/11/07/19

8/11/07/19

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, July 15, 2011 10:36:18 AM

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Work Order ID: 71998

Parent Item: D3684-043

Parent Item Name: MOUNT ASSEMBLY

Start Date: 7/15/2011

Required Date: 7/22/2011

Start Qty: 2.00

Required Qty: 2.00

D3692-1 Manufactured No

110 Each

131.0000 8



SPACER

Location

Loc Qty

Loc Code

ST075

131

51467

131

MS21043-3

Purchased No

110 Each

872.0000 4



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

800

112314

65

118077

735

16
E 5/11/07/19

16
8
E 5/11/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

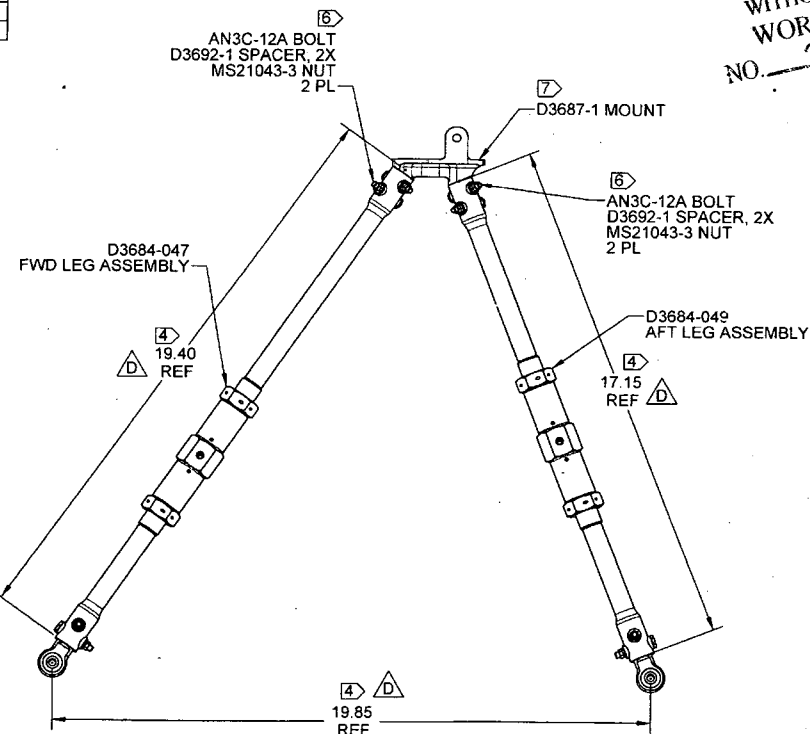
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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT

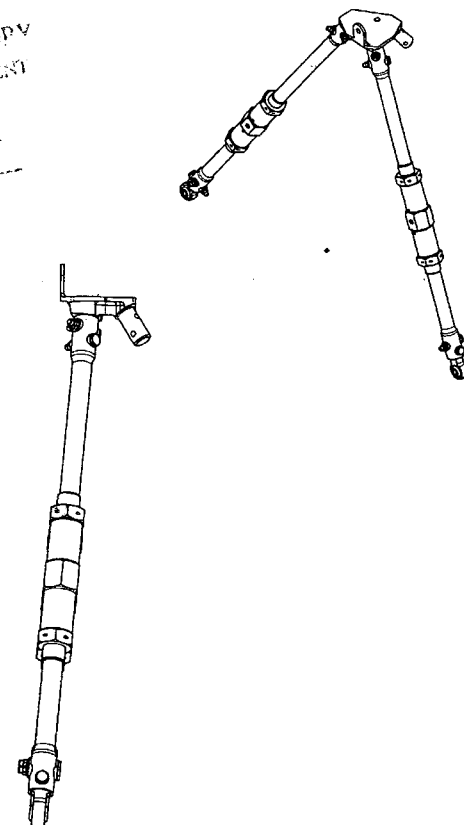


D3684-043 MOUNT ASSEMBLY





NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71998



RELEASE
2010-03-15

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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